

# Work Order ID 60757

Thursday, July 22, 2010 10:49:28 AM

Page 1

Item ID: D2989-041

Revision ID:

Item Name: Basket Lid Assembly

Start Date: 7/22/2010 Start Qty: 1.00

Required Date: 7/29/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: [Signature] Date: 6-7-21 Tooling: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Cust Item ID:  
Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100



Large Fab

Large Fab

Large Fab

0.00

0.00

## Memo

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig  
\*\*\*\*cut cutouts with zip cut as per dwg D3832\*\*\*\*

3- remove from jig and weld lable plate as per dwg D2989  
A/R ER316 S.S. Rod Batch: 110875

QC9- Inspect visual per QSI004- Fusion Welds

0.00

## Memo

0.00

110



QC

Quality Control

RD 10.07.29

Pl 10.07.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60757

Thursday, July 22, 2010 10:49:28 AM

Page 2

Item ID: D2989-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 7/22/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
130 Powdercoat Powder Coating	* pressure - was # White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel  Memo 1- Plug holes prior to powder coating 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989	0.00 0.00							

1ST COAT:  
START TIME: 2:30pm  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 3:00pm  
\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*  
2ND COAT:  
START TIME: 3:15pm  
OVEN TEMPERATURE: 400°F  
FINISH TIME: 3:45pm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, July 22, 2010 10:49:28 AM

Page 3

Item ID: D2989-041	Accept	Setup	Start
Revision ID:		Stop	
Item Name: Basket Lid Assembly			
Start Date: 7/22/2010 Start Qty: 1.00	Cust Item ID:		
Required Date: 7/29/2010 Req'd Qty: 1.00	Customer:		
Reference:		Run	Start
Approvals: Process Plan: _____ Date: _____ Tooling: _____			Stop
QC: _____ Date: _____ SPC (Y/N): _____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
131 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>M113028</u>  Memo Mask lid prior to spray paint black and wing walk as per dwg A/R Spray paint black batch: <u>M114332</u>	0.00 0.00		M 10/07/30		X1	0		
140 QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00		8/10/07/30		10			
141 Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo D 350-607-013 w/ 60756	0.00 0.00		27 M 10/07/30		1	0		

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Thursday, July 22, 2010 10:49:28 AM

Page 4

Item ID: D2989-041

Accept

Setup Start

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Stop

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Start Date: 7/22/2010 Start Qty: 1.00

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Required Date: 7/29/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/30 H

10-7-30  
①

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# Picklist Print

Thursday, July 22, 2010 10:49:32 AM

Page 1

Work Order ID: 60757

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly




Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	16.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>16</div> <div></div> </div>													
<div> <div>59275</div> <div>4</div> <div></div> </div>													
<div> <div>60172</div> <div>12</div> <div></div> </div>													
D2506  Label Plate		Manufactured	No			100	Each	6.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>6</div> <div></div> </div>													
<div> <div>57836</div> <div>1</div> <div></div> </div>													
<div> <div>60272</div> <div>5</div> <div></div> </div>													
D2512-7  Rib		Manufactured	No			100	Each	5.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>5</div> <div></div> </div>													
<div> <div>58026</div> <div>1</div> <div></div> </div>													
<div> <div>59864</div> <div>4</div> <div></div> </div>													

PD 10.07.26

②

PD 10.07.26

①

PD 10.07.26

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Thursday, July 22, 2010 10:49:32 AM

Work Order ID: 60757

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

41.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

41

46086

2

51745

1

57185

1

59265

1

60198

36

W

25HL



10.07.26

D2989-13

Manufactured No

100

Each

6.0000

2

2



Rib

Location

Loc Qty

Loc Code

WA

6

59320

2

60576

4



10.07.26

D2989-19

Manufactured No

100

Each

6.0000

2

2



Rib

Location

Loc Qty

Loc Code

WA

6

59865

2

60175

4



10.07.26

D3832-3

Manufactured No

100

Each

3.0000

1

1



Mesh (Lid)

Location

Loc Qty

Loc Code

WA

3

59296

1

59411

2



10.07.28

Thursday, July 22, 2010 10:49:32 AM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Thursday, July 22, 2010 10:49:32 AM

Work Order ID: 60757

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-3 Manufactured No

100

Each

13.0000

2

2



Mesh (Lid End)

Location

Loc Qty

Loc Code

WA

13

46308

1

59903

6

60672

6

D3836-041 Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Basket Lid, LH)

Location

Loc Qty

Loc Code

WA

3

59861

1

60178

2

D3836-042 Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Basket Lid, RH)

Location

Loc Qty

Loc Code

WA

3

59319

1

60179

2

D3852-041 Manufactured No

100

Each

3.0000

1

1



Rib Assembly

Location

Loc Qty

Loc Code

WA

3

59008

1

60180

2

Thursday, July 22, 2010 10:49:32 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 4

Thursday, July 22, 2010 10:49:32 AM

Work Order ID: 60757



Parent Item: D2989-041



Parent Item Name: Basket Lid Assembly

Start Date: 7/22/2010

Required Date: 7/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

3.0000

1

1



Rib Assembly



10.07.26

Location

Loc Qty

Loc Code

WA

3

59009

1

60181

2

①

Thursday, July 22, 2010 10:49:32 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

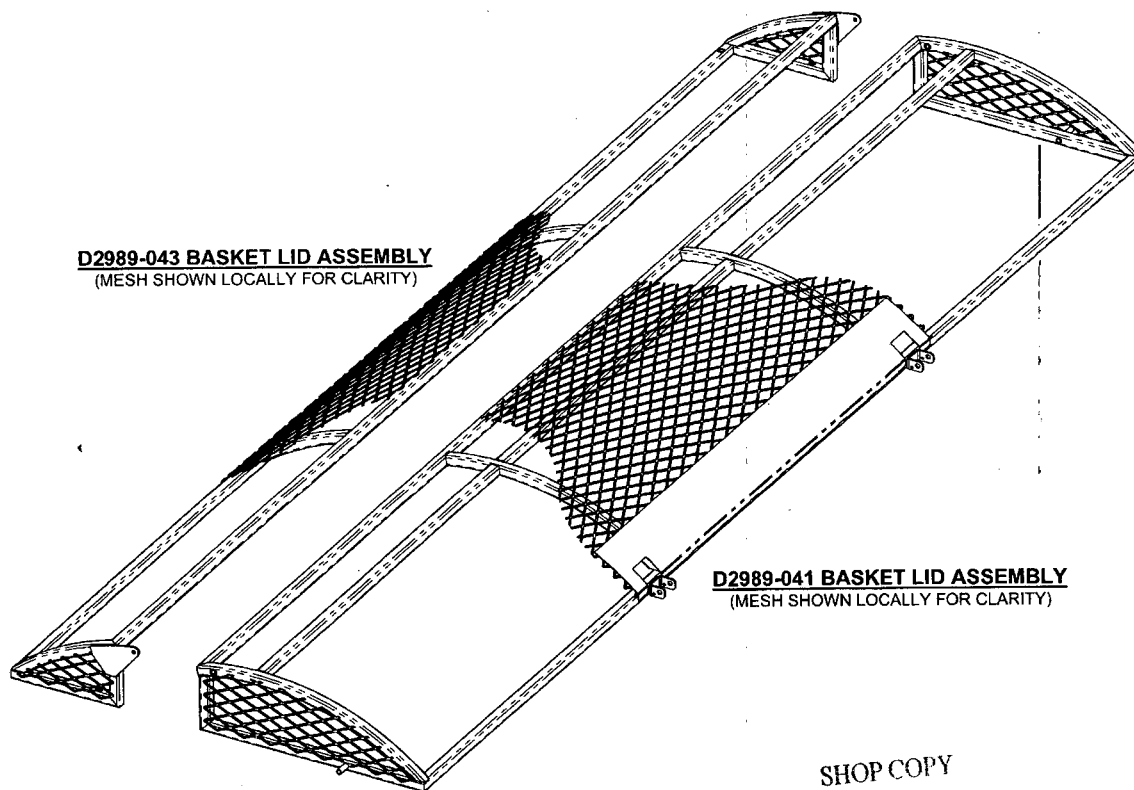
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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**NOTE:** Date & initial all entries



**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

**RELEASED**  
08/11/18

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60757  
BS10-7-21

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs  
8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3838 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

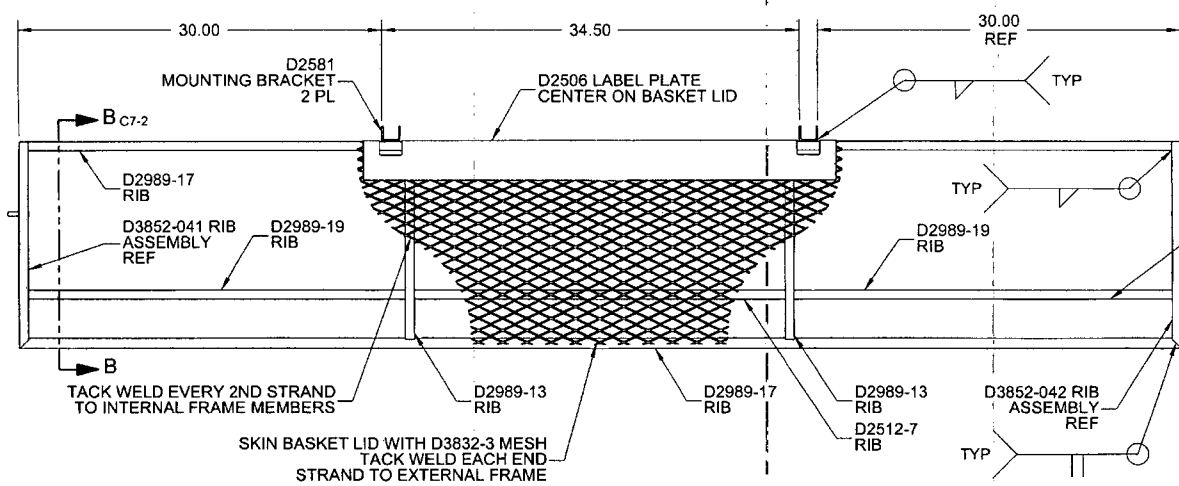
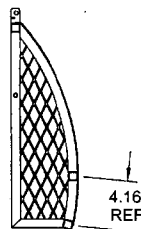
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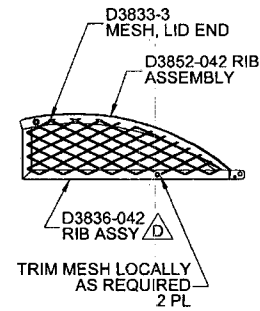
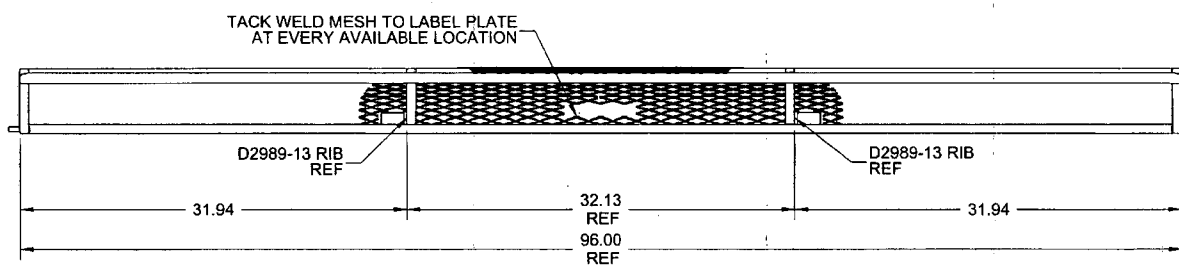
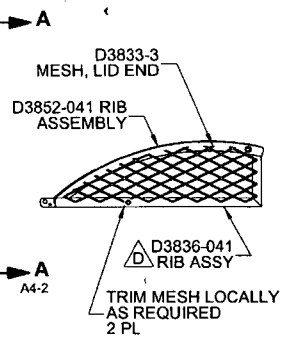
**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

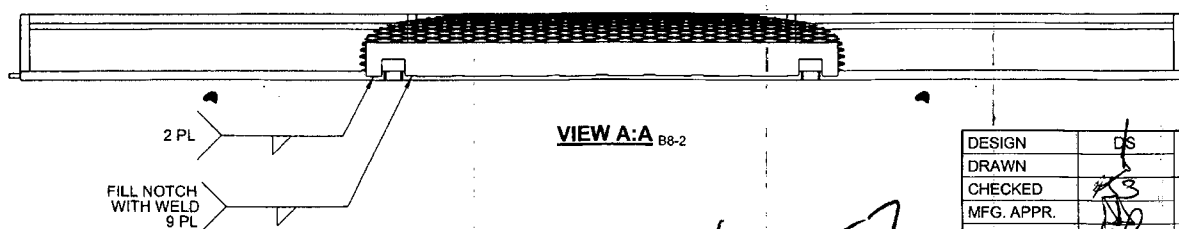
**SECTION B-B**  
D7-2



TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D  
BLACK ANTI-SKID PAINT THIS SECTION



**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)



**VIEW A:A** 88-2

**RELEASED**  
08/11/81

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	KS	DRAWING NO. D2989	REV. D
MFG. APPR.	DD		SHEET 2 OF 5
APPROVED	WV	TITLE	SCALE
DE APPR.	#	<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

*4060757*

8 7 6 5 4 3 2 1

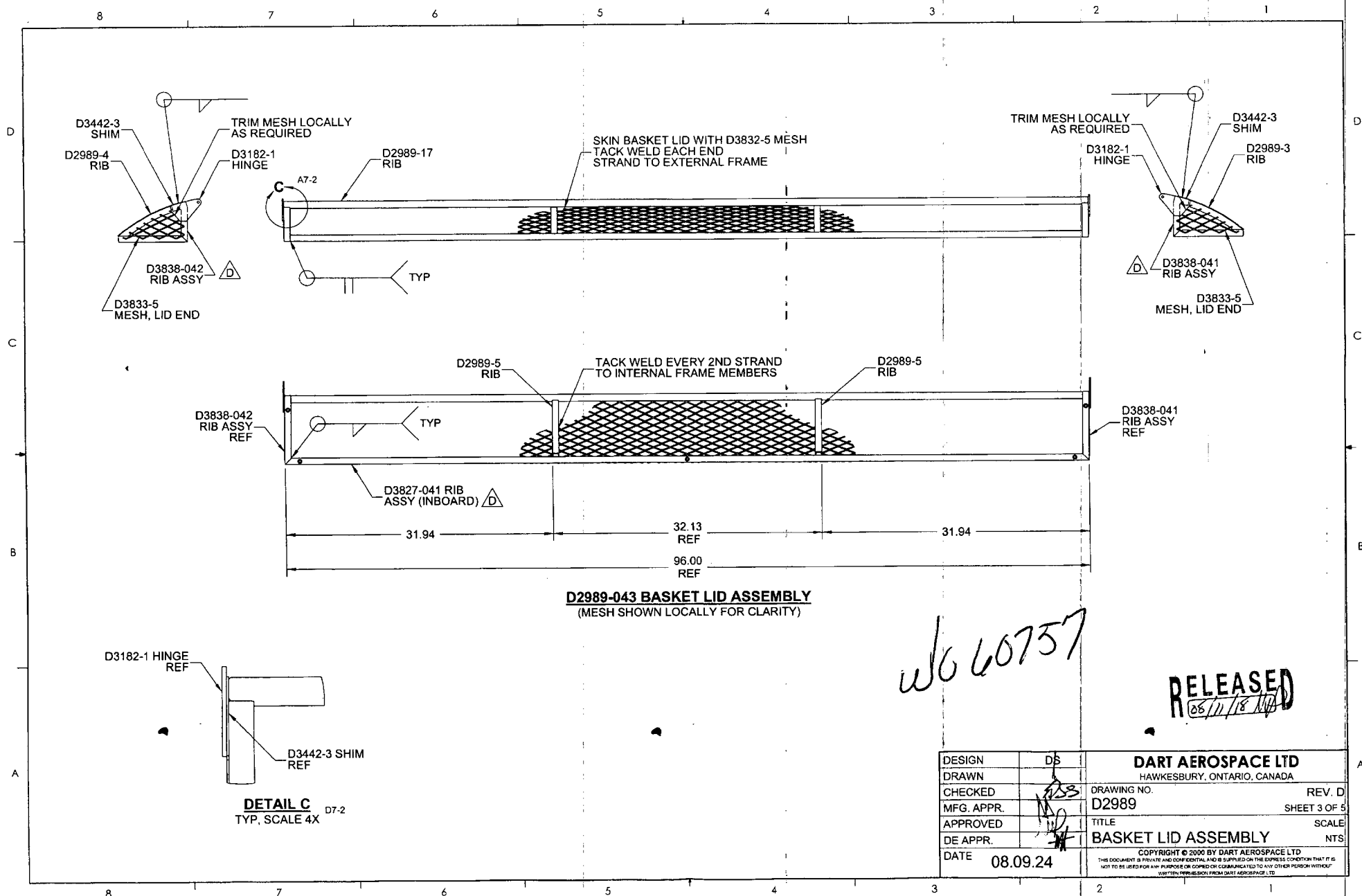
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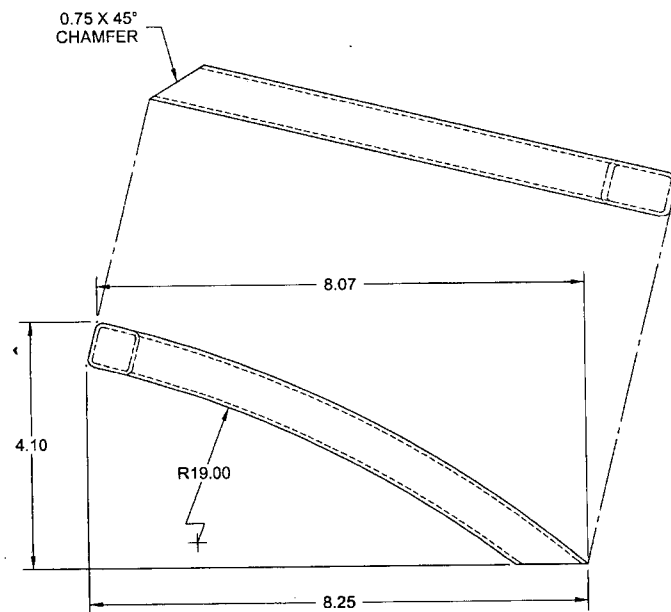
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

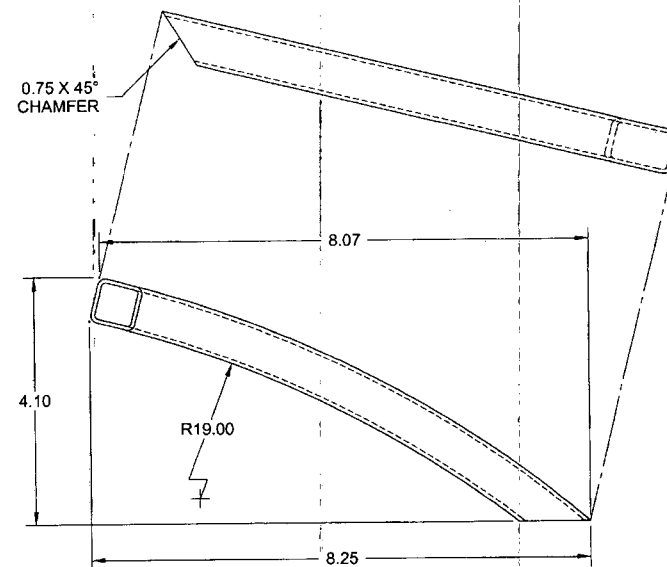
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



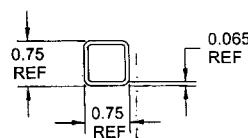
**D2989-3 RIB**



**D2989-4 RIB**

**NOTES:**

- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION  
VIEW**

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**RELEASED**  
08/11/18

W/O 60757

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

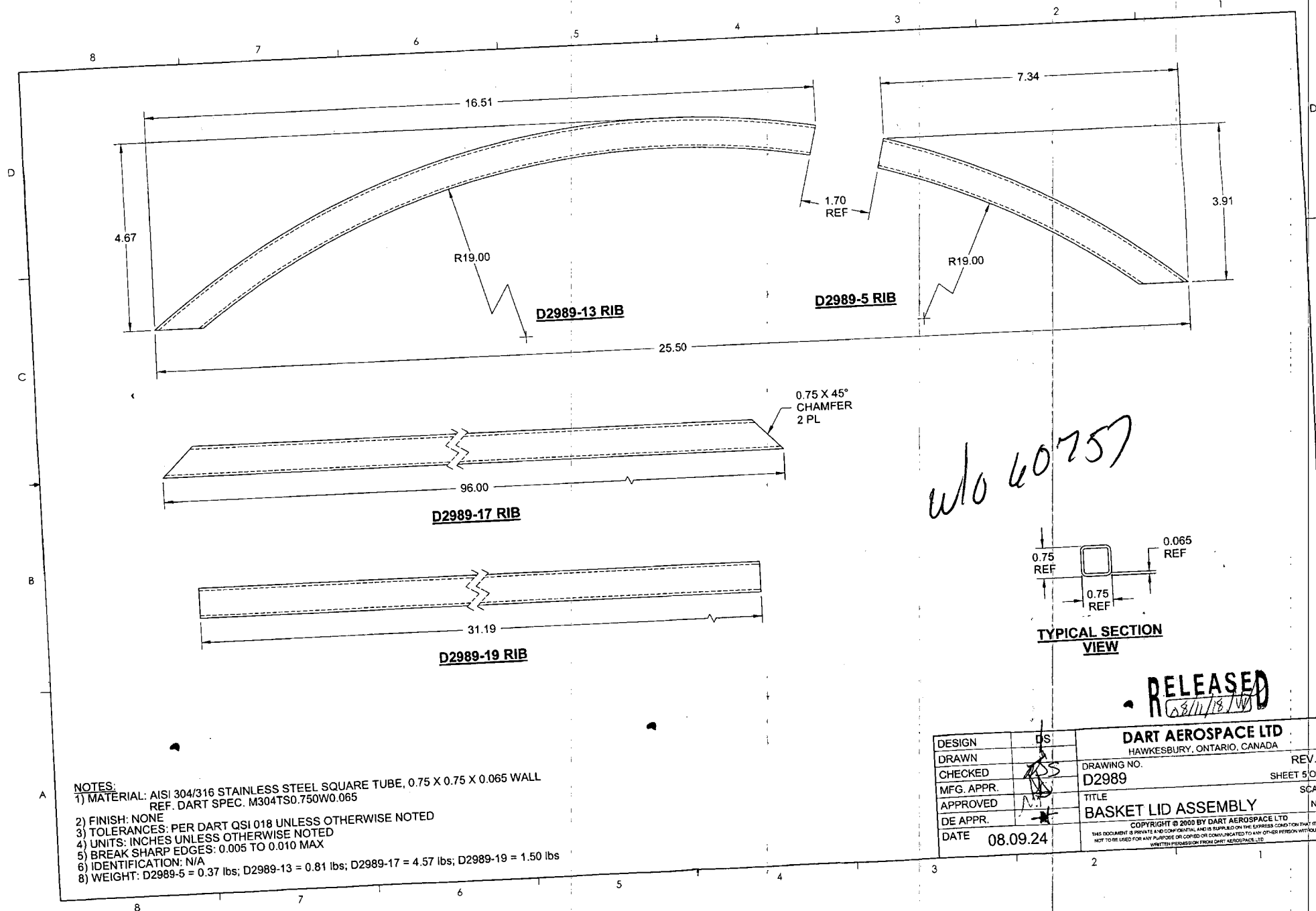
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

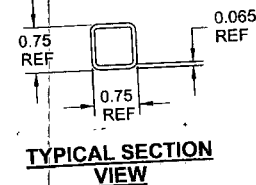
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O 40757



RELEASED  
28/11/18

DESIGN	DS	DART AEROSPACE LTD	REV. D
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	SHEET 5 OF 5
CHECKED	DS	D2989	SCALE
MFG. APPR.	DS	TITLE	NTS
APPROVED	DS	BASKET LID ASSEMBLY	
DE APPR.	DS		
DATE	08.09.24		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries